

Work Order ID 80570

80570

Page 1

February-23-12 11:21:21 AM

Item ID: D3954-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: GWT Knob

Start Date: 23/02/2012 Start Qty: 8.00

8

Cust Item ID:

Required Date: 08/03/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan: M.C.J.

Date: 12/02/12

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3954	C								

100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3854

Dwg Rev: C

Prog Rev: C

2-Deburr if necessary

B12-3-3

(12)

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B12-3-3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 80570

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Page 2

Item ID: D3954-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: GWT Knob
 Start Date: 23/02/2012 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 08/03/2012 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	<i>SA</i>	<i>12/03/08</i>		<i>8/12</i>	<i>0</i>		
130 *130* Mill Conv Conventional Milling Machine	Memo 1-OPEN TO TAP DRILL SIZE 2-TAP AS PER DWG D3954	0.00 0.00	<i>B.A</i>	<i>12/03/08</i>		<i>8/12</i>	<i>0</i>		
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	<i>SC</i>	<i>12/03/08</i>		<i>8/12</i>			

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Page 3

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Item ID: D3954-3 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: GWT Knob
 Start Date: 23/02/2012 Start Qty: 8.00 *8* Cust Item ID:
 Required Date: 08/03/2012 Req'd Qty: 8.00 *8* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: <u>97</u>	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

12/3/28
 MF
 12-03-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

February-23-12 11:21:26 AM

Page 1

Work Order ID: 80570

80570

Parent Item: D3954-3

D3954-3

Parent Item Name: GWT Knob

Start Date: 23/02/2012

Required Date: 08/03/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A 11.08.16 AS PER REV.C DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.375X03.000		Purchased	No			100	f	42.0000	0.02778	0.233937	1,5		

M304B0 375X03 000

**

B12-3-3

M304 SS bar .375 x 3.00

Location

Loc Qty

Loc Code

MAT050

42

119654

7

120204

24

3

11

~~118523~~

118523

118523

(12)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

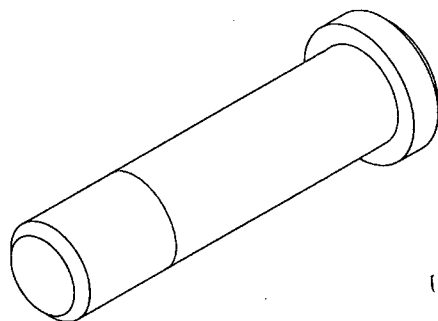
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

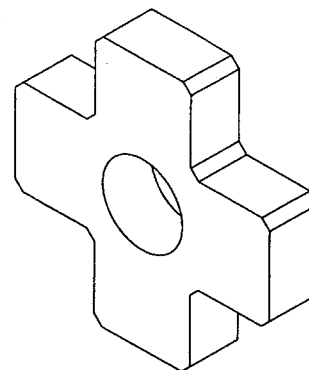
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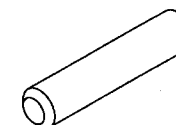
NOTE: Date & initial all entries



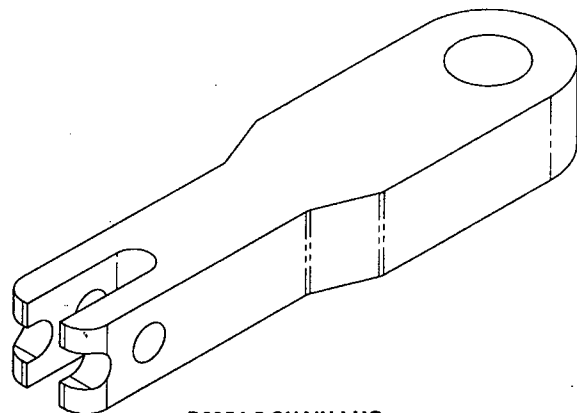
D3954-1 GWT PIN



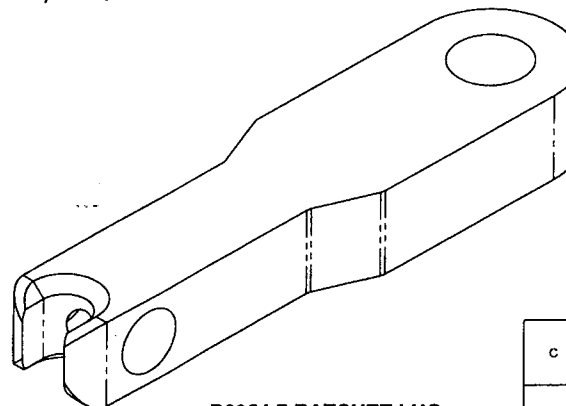
D3954-3 GWT KNOB



D3954-9 GWT CHAIN PIN



D3954-5 CHAIN LUG



D3954-7 RATCHET LUG

SHOP COPY
RETURN TO
DRAWING
ENGINEER POLLED COPY
SUBMIT TO MANAGEMENT
WITHIN 14 DAYS
WORK ORDER
NO. 80570 M.L.J.

12/02/23

RELEASED
2011-07-29

C	MATERIAL UPDATE FOR D3954-1/3: NOW STAINLESS STEEL ONLY (A8-2). FINISH CHANGED TO "NONE" FOR D3954-1/3 (A8-2). TOLERANCE ON Ø0.750 WAS Ø0.75 MAX (D3-3 & D7-3). D3954-9 NOW A PURCHASED PART (A2/A8-3). REASON: PAR11-113.	MB	11.07.27
B	MATERIAL UPDATE FOR ALL COMPONENTS WAS STAINLESS STEEL IS CARBON STEEL FOR ALL COMPONENTS. FINISH FOR ALL COMPONENTS WAS RED POWDER COAT IS YELLOW SPRAY PAINT.	AJS	09.10.15
A	NEW ISSUE	AJS	09.05.26
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS/DSTOW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3954	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	N/A	MISC MACHINED PARTS GWT KIT	NTS
DATE	11.07.27	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

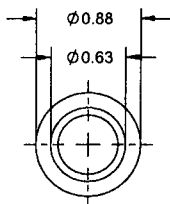
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

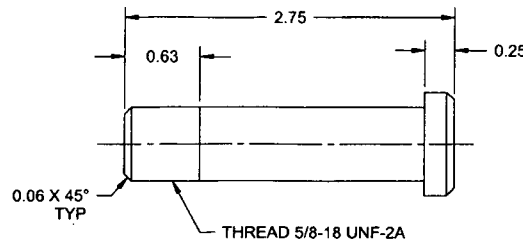
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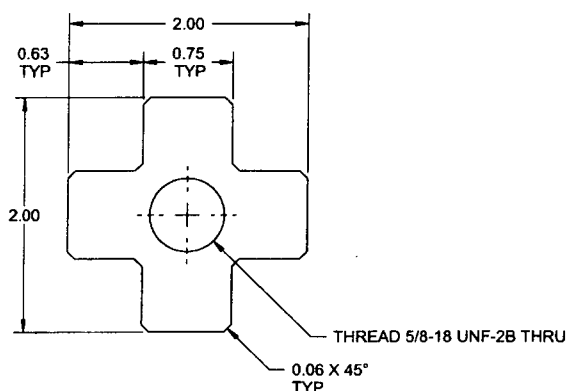
NOTE: Date & initial all entries



D3954-1 GWT PIN



80570



D3954-3 GWT KNOB

NOTES:

- 1) MATERIAL -1: AISI 303/304/316 STAINLESS STEEL ROUND BAR
PER ASTM A582 (303) OR ASTM A276 (304/316)
REF DART SPEC M303R OR M304R
-3: AISI 303/304/316 STAINLESS STEEL SHEET
PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316)
OR ASTM A240 OR ASME SA240
REF DART SPEC M303S OR M304S
OR:
AISI 303/304/316 STAINLESS STEEL BAR OR AISI 304/316 PLATE
PER ASTM A582 (303) OR A276 (304/316) OR ASTM A240 (304/316)
REF DART SPEC M303B OR M304B

- 2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3954-X" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT -1: 0.26 lbs
-3: 0.23 lbs

RELEASED
2011-07-29

DESIGN	AJS/DSTOW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3954	REV. C
MFG. APPR.		SHEET 2 OF 3	
APPROVED		TITLE	SCALE
DE APPR.	N/A	MISC MACHINED PARTS GWT KIT	
DATE	11.07.27	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

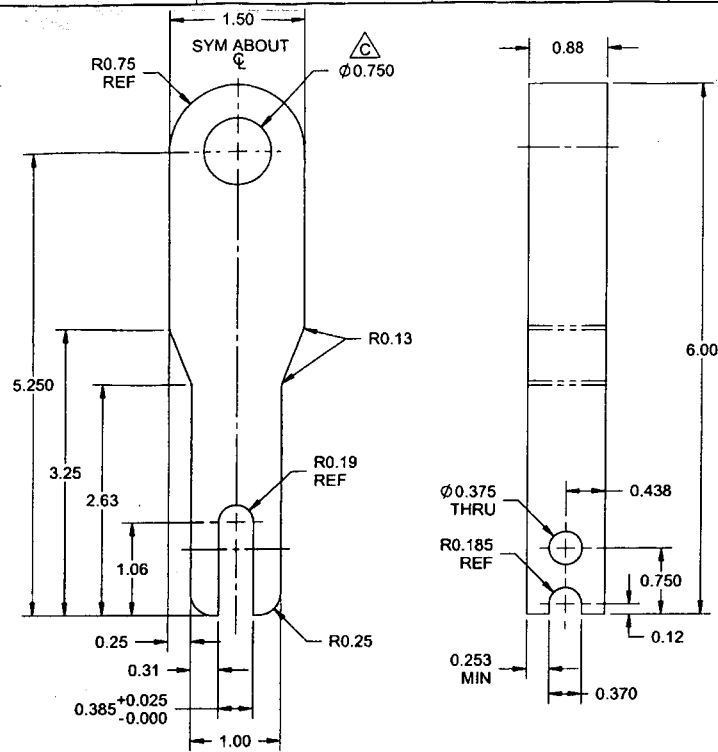
W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

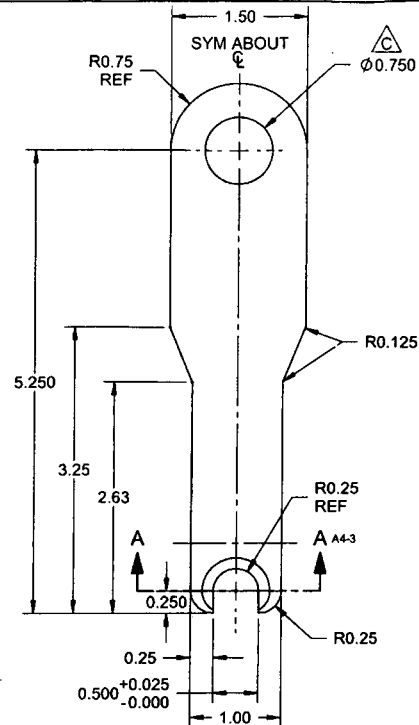
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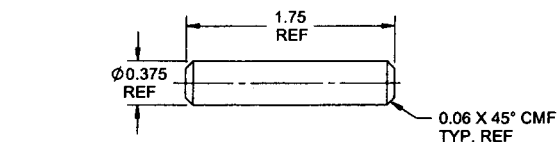
NOTE: Date & initial all entries



D3954-5 CHAIN LUG



D3954-7 RATCHET LUG



D3954-9 GWT CHAIN PIN

NOTES:

1) MATERIAL:

-5/-7: AISI 1010-1025 MILD STEEL BAR
PER DART SPEC M1010-B

-9: PURCHASE PART FROM MCMASTER-CARR:
P/N 98381A630 (MILD STEEL)

ALTERNATE MATERIAL:

-5/-7: AISI 303/304/316 STAINLESS STEEL BAR OR AISI 304/316 PLATE
PER ASTM A582 (303) OR A276 (304/316) OR ASTM A240 (304/316)
REF DART SPEC M303B OR M304B

-9: PURCHASE PART FROM MCMASTER-CARR:
P/N 90145A630 (STAINLESS STEEL)

2) FINISH -7 ONLY: SPRAY PAINT YELLOW WITH BERTRAND CG1031B PER DART QSI 005 4.2

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

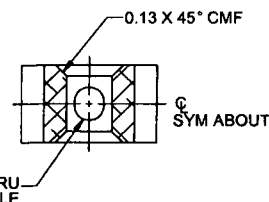
4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3954-X" USING FINE POINT PERMANENT INK MARKER

7) WEIGHT -5/-7: 1.56 lbs EACH

-9: 0.05 lbs REF



SECTION A-A C3-3

DESIGN	AJS/DSTOW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	AJS	DRAWING NO.	REV. C
MFG. APPR.		D3954	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.	N/A	MISC MACHINED PARTS GWT KIT	NTS
DATE	11.07.27	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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RELEASED
2011-07-29

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